

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004210**Date Inspected:** 22-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhang Bao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Assembly**Summary of Items Observed:**

This report serves to document the events occurring on this date at the following location. Caltrans Quality Assurance (QA) Inspector Robert Vatcher arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

OBG Assembly Bay

Mid bay- Welding operation on CA010-033 with SMAW in the 3G position. QA corrected the welder and both QC parties about utilizing slag hammer and wire brush upon termination of a weld layer.

4BW-

Welding is performed at side plate stiffener welds for sp073 to sp073 extension. QA observed gaps exceeding the root opening tolerances and asked ZPMC QC personnel Zhang Bao Lei about this operation. Mr. Lei mentioned that no tack welding will occur where root openings are too wide. Buttering first and then tack welding. QA concurred.

4AW-

QA observed the removal of tack welds at super deck panels to floor beam flanges to facilitate repairs to cracks in the U-rib to deck panel partial penetration welds.

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North Fabrication Area (Outside)

QA observed Ultrasonic testing (UT) on deck panels DP536-001, DP94-001, DP227-001 and DP146-001 by UT operators Li Li Ming and Geng Sheng. QA queried both operators with the assistance of interpreter Shen Xue Jun that D1.5 requires a transducer oscillation of 15. Both operators corrected their scanning technique and rescanned the welds where required.

The above mentioned items as observed & documented by QA appear to conform to the contract documents.

Summary of Conversations:

No relevant conversations this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 138-1694-2685, who represents the Office of Structural Materials for your project.

Inspected By:	Vatcher,Robert	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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